

Date: Monday, 07/04/2008 11:47:02 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FWD X-TUBE
Job Number :	38424		
Estimate Number :	10006		
P.O. Number :		Part Number :	D2889
This Issue :	07/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2889 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	38423	Drawing Revision :	B
	Type :	Material :	
	LANDING GEAR	Due Date :	10/05/2008
Written By :		Qty:	1
Checked & Approved By :	<u>JTO 08.04.06</u>	Um:	Each
Comment :	Est Rev:A New Issue 05-10-25 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6005180	Crosstube material
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Crosstube material

Pick:

Qty Part number Description Batch

1 D2889 Fwd Crosstube 334687

EL 8-4-9

2.0	BENDING	BENDING MACHINE - SKIDTUBES
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**Comment:** LANDING GEAR RESOURCE 1

1-Bend D2889 as per Dwg D2889 and Folio FT001

EL 8-4-9

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Deburr and Polish

used on w/o 37946
 u/a F 10/04/09

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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**Comment:** DIMENSIONAL CHECK OF X-TUBES

S 08/04/09

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Acid etch and alodine as per QSI 005 4.1
 Inside and outside of tube

u/a F
 used on w/o 37946
 12/04/09

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 38424

Part Number: D2889

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ultra

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

~~used~~ on w/o

used on w/o 37946
08/04/08

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/15

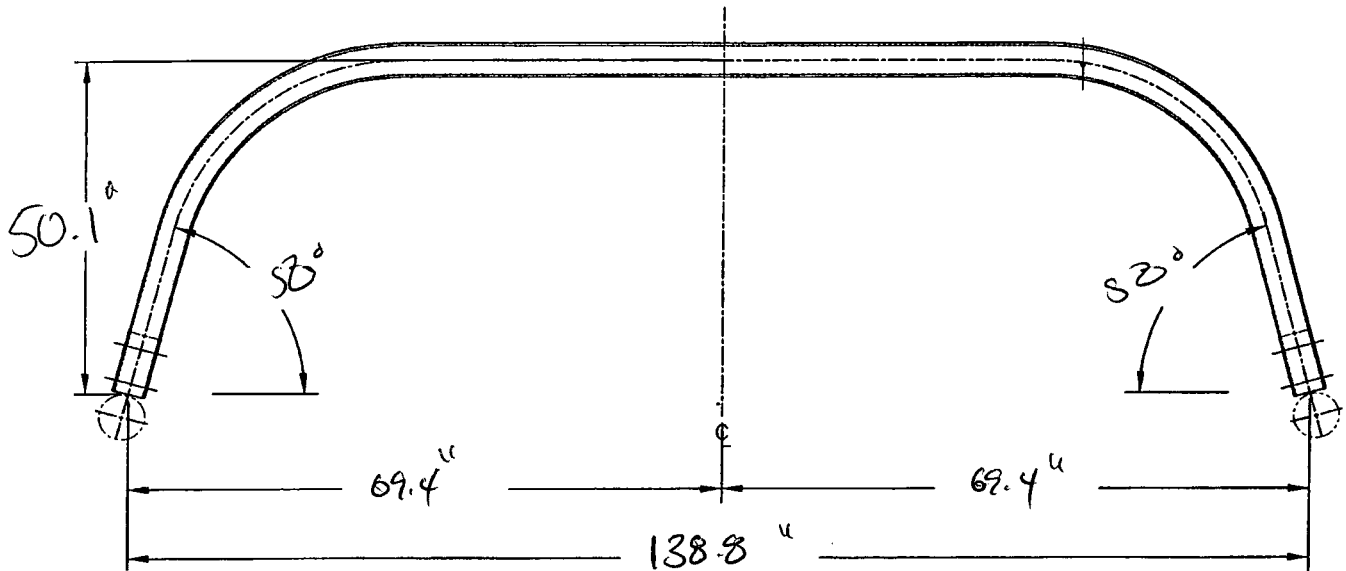
Job Completion



mf 08-04-10
u

DART AEROSPACE LTD		Work Order:	38424
Description: Crosstube Fwd		Part Number:	D2889
Inspection Dwg: D2889	Rev: B	Page 1 of 1	

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



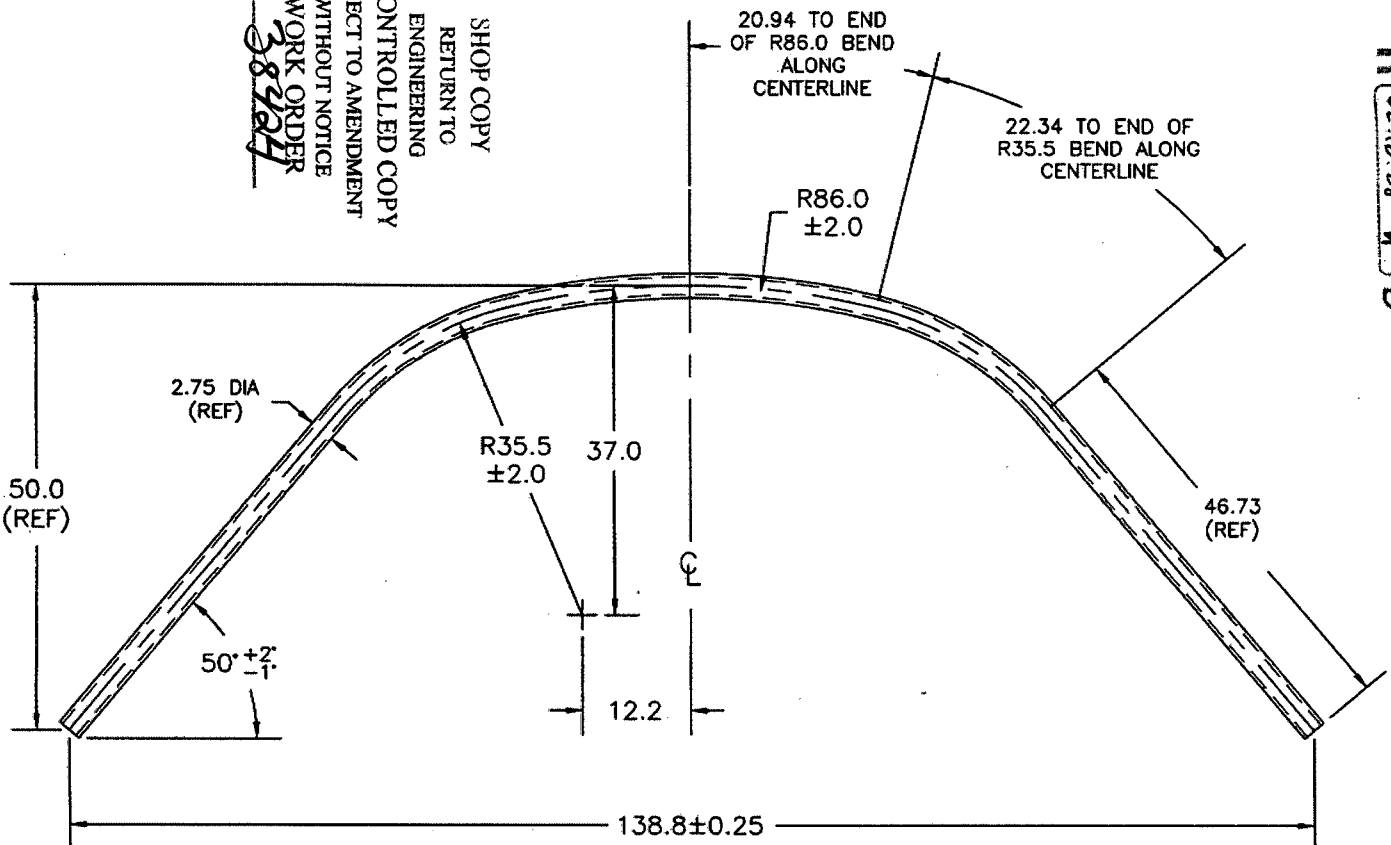
Comments

QC15 Inspection	58606/09
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>

DART**RELEASED**
02.10.28 #

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
#	CP	DRAWING NO.	REV. B
CHECKED #	APPROVED #	D2889	SHEET 1 OF 1
DATE		TITLE	SCALE
02.10.18		FWD CROSSTUBE	1:20
A	99.05.21	NEW ISSUE	
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38424

NOTES

- 1) MATERIAL: MANUFACTURE FROM D6005-180 (Ø2.75 OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.